

Date: Thursday, 11/16/2006 4:25:26 PM
 User: Kim Johnston

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	STEP (CASTING DETAIL)
Job Number :	29486		
Estimate Number :	10510		
P.O. Number :	N/A	Part Number :	D25763
This Issue :	11/16/2006	S.O. No. :	N/A
Prsht Rev. :	NC	Drawing Number :	D2576 REV. E1
First Issue :	N/A	Project Number :	N/A
Previous Run :	23060	Drawing Revision :	E1
Written By :		Material :	N/A
Checked & Approved By :		Due Date :	10/5/2006
Comment :	Est: E 02-08.19 Consolidated D2576-1 and D2576-3 KJ/RF		

Qty: 96 Um: 100 Each

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
----------------	------------------------------	----------------------

1.0	D25761	Step (Casting Detail)
-----	--------	-----------------------



Comment: Qty.: 1.0000 Each(s)/Unit Total: 100.0000 Each(s)

Pick:

Qty	Part#	Description	Batch
1	D2576-1	Step (Casting Detail)	<u>29514</u>

2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
-----	-------	--------------------------------

**Comment:** HAAS1

1- Machine as per Folio FA332 and Dwg D2576
 2- Deburr

J.F. / J.L. 06/12/08

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--

**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

J.F. / J.L. 06/12/08

4.0	QC8	SECOND CHECK
-----	-----	--------------

**Comment:** SECOND CHECK

MS 06/12/09

96

5.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------

**Comment:** PACKAGING RESOURCE #1

Identify and Stock
 Location: LG

BE 06/12/11

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D2576-3 PAR #: N/A Fault Category: Prod / machined parts NCR: Yes No DQA: [Signature] Date: 06/12/12
 QA: N/C Closed: [Signature] Date: 06.12.12

NCR: <u>29486</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
06/12/08	2	The pocket .063" deep is to thin. 2 parts	[Signature] 06/12/08	Scrap: destroy. no replace	J.F. 06/12/08	[Signature] 06.12.12	[Signature] 06/12/08	[Signature] 06.12.11
06/12/09	2	- 1 part came out of jig while machining - 1 part .063 pocket is too deep	[Signature] 06/12/09	Scrap: destroy no replace.	IL 06/12/09	[Signature] 06.12.12	[Signature] 06/12/09	[Signature] 06.12.11

NOTE: Date & initial all entries

Date: Thursday, 11/16/2006 4:25:26 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STEP (CASTING DETAIL)

Job Number: 29486

Part Number: D25763

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

SS 06/12/12

Job Completion



U Se 17-01

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	29486
Description: Step		Part Number:	D2576-3
Inspection Dwg: D2576	Rev: E1		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

x

First Article

Prototype

[illegible]

Measured by:	J.F.	Audited by:	SA	Prototype Approval:	N/A
Date:	06/12/07	Date:	06/12/07	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.02.10	New Issue	KJ/RF	

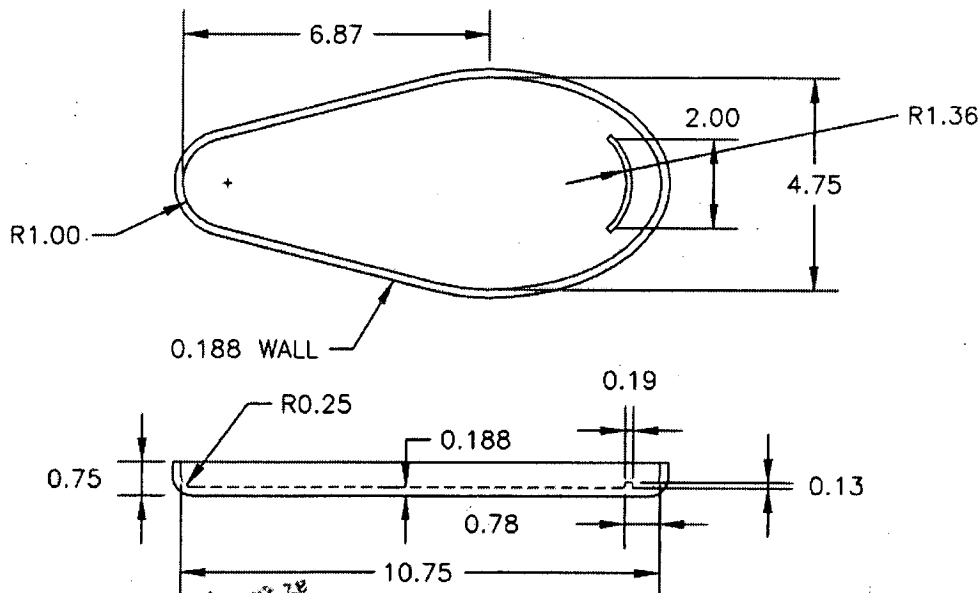


DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED RF	APPROVED KE	DRAWING NO. D2576	REV. E SHEET 1 OF 1
DATE 99.09.07		TITLE STEP	SCALE 1:4
A	96.09.18	NEW ISSUE	
B	96.11.28	REMOVE POCKETS, ADD HOLE	
C	98.08.18	ADD POCKETS & SLOTS FOR WELDING	
D	99.08.18	CHNG. SLOT SIZE AND LOC.(TSR A1069)	
E	99.09.07	CHNG. 0.50 HOLE LOC. AND ADD NOTE	
E1	RF 03.04.29	7.05 WAS 6.61	

RELEASED
99.09.08 DS

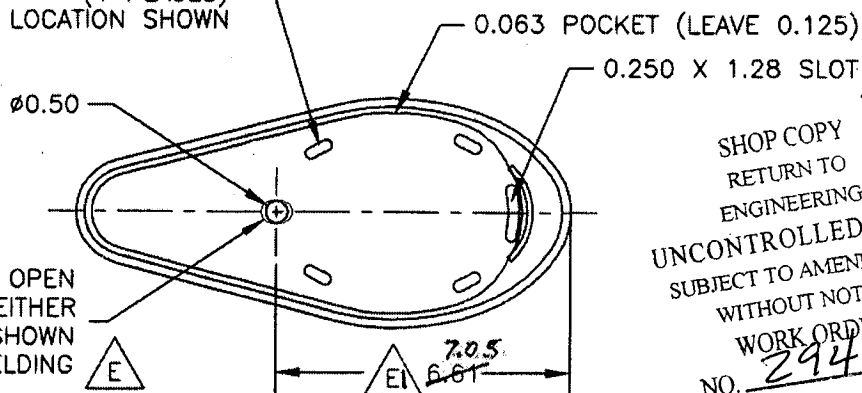
CASTING DETAIL (D2576-1) ^{#00.08.26}
_{CP 00.08.28}

MATERIAL: CAST ALUMINUM ALLOY A-535.2
BREAK SHARP EDGES 0.025 TO 0.050
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
ALL DIMENSIONS ARE IN INCHES



MACHINING DETAIL (D2576-3) ^{#00.08.28}
_{CP 00.08.28}

△ 0.250 X 0.65 SLOT
(4 PLACES)
IN APPROX. LOCATION SHOWN



IT IS ACCEPTABLE TO OPEN
THIS HOLE 0.125 IN EITHER
DIRECTION AS SHOWN
FOR WELDING

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 29486